

Work Order ID 65940

Thursday, January 27, 2011 1:12:10 PM

Page 1

Item ID: D4018-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Short Basket Lid Assembly (350)

Start Date: 1/28/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 2/14/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: UMF Date: 11-01-27 Tooling:

Date:

Run Start

QC: Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4018

C

100

Weld per dwg A/R S.S. rod Batch: 2114649 0.00

Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D4018 using DT9607B
2- weld hinge (3) and Mounting brackets as per dwg D4018

inspect before welding mesh

3- tack weld mesh on basket as per dwg D4018

***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***11/02/14 (1x)

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11-02-16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Accept

**Setup Start**

Stop



Start Date: 1/28/2011 **Start Qty:** 1.00

**Cust Item ID:**

Required Date: 2/14/2011 **Req'd Qty:** 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| QC Quality Control | Memo | 0.00 | | | | | | | EB 10/02/16 @ |
| 160 | Identify as per dwg & Stock Location: C-A | 0.00 | | | | | | | |
| Packaging Packaging | Memo w/o 65938 | 0.00 | | | | | | | EB 11/02/16 @ |
| 170 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC Quality Control | Memo | 0.00 | | | | | | | CX 11/02/16 |

EB 10/02/16 0

EP 11/02/16 ①

OK 11/02/16
mf
11-02-16

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NOTE: Date & initial all entries

Picklist Print

Thursday, January 27, 2011 1:12:07 PM

Page 1

Work Order ID: 65940

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)





Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| ✓ D4018-1  Rib | | Manufactured | No | | | 100 | Each | 2.0000 | 2 | 2 | | | |
| <div> <div>Location</div> <div>WA</div> <div>59252</div> </div> <div> <div>Loc Qty</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> </div> | | | | | | | | | | | | | |
| ✓ D4018-3  Rib | | Manufactured | No | | | 100 | Each | 2.0000 | 2 | 2 | | | |
| <div> <div>Location</div> <div>WA</div> <div>59253</div> </div> <div> <div>Loc Qty</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> </div> | | | | | | | | | | | | | |
| ✗ D4016-3  Hinge Half, Lid | | Manufactured | No | | | 100 | Each | 14.0000 | 3 | 3 | | | |
| <div> <div>Location</div> <div>WA</div> <div>64845</div> <div>65425</div> </div> <div> <div>Loc Qty</div> <div>14</div> <div>8</div> <div>6</div> </div> <div> <div>Loc Code</div> <div></div> </div> | | | | | | | | | | | | | |
| ✓ D4018-5  Rib | | Manufactured | No | | | 100 | Each | 16.0000 | 6 | 6 | | | |
| <div> <div>Location</div> <div>WA</div> <div>64067</div> </div> <div> <div>Loc Qty</div> <div>16</div> </div> <div> <div>Loc Code</div> <div></div> </div> | | | | | | | | | | | | | |

B65915 (2x) 11/02/14

B65918 (2x) 11/02/14

B65951 (1x) 11/02/14

B65428 (6x) 11/02/14

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Thursday, January 27, 2011 1:12:07 PM

Page 2

Work Order ID: 65940

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

✓

D4035-041

Manufactured No

100 Each

1.0000

1 1



Lid Rib Assembly, Fwd (350 Basket)



B65426 (1x) SY 11/02/14

Location

Loc Qty

Loc Code

WA

1

64849

1

✓

D4035-043

Manufactured No

100 Each

1.0000

1 1



Lid Rib Assembly, Aft (350 Basket)



B65427 (1x) SY 11/02/14

Location

Loc Qty

Loc Code

WA

1

64850

1

✓

D2581

Manufactured No

100 Each

29.0000

2 2



Mounting Bracket



SY 11/02/14

Location

Loc Qty

Loc Code

WA

29

64112

20

64425

9

✓

D4020-7

Manufactured No

100 Each

0.0000

1 1



Mesh (350 Basket Short, Lid)



SY B65917 (1x)

D4021-3

Manufactured No

100 Each

3.0000

1 1



Data Plate



11/02/14
B65916 (1x) SY 11/02/14

Location

Loc Qty

Loc Code

WA

3

56050

1

64924

2

Thursday, January 27, 2011 1:12:08 PM

Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, January 27, 2011 1:12:08 PM

Page 3

Work Order ID: 65940



Parent Item: D4018-041



Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

D2728-3

Manufactured No

140

Each

0.0000

1

1



Dart Logo label

M 115050



(x1) 24 11/02/11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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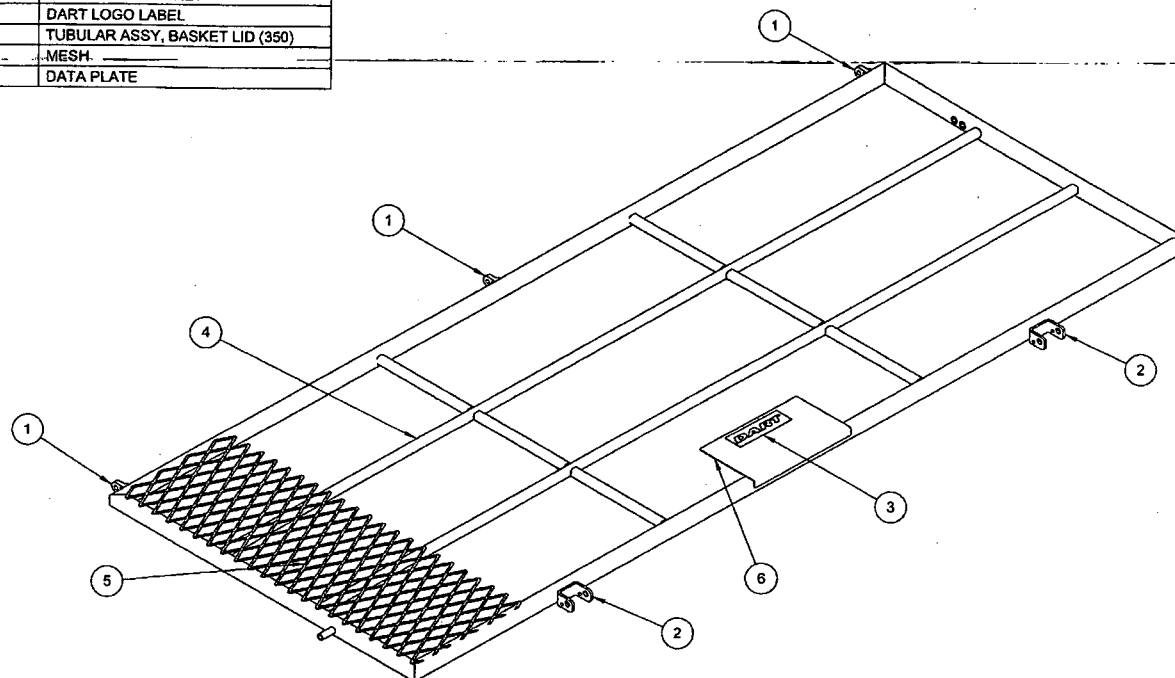
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NOTE: Date & initial all entries

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|-----------|--------------------------------|
| | X | D4018-041 | SHORT BASKET LID ASSY (350) |
| 1 | 3 | D4016-3 | HINGE HALF, LID |
| 2 | 2 | D2581 | MOUNTING BRACKET |
| 3 | 1 | D2728-3 | DART LOGO LABEL |
| 4 | 1 | D4018-101 | TUBULAR ASSY, BASKET LID (350) |
| 5 | 1 | D4020-7 | MESH |
| 6 | 1 | D4021-3 | DATA PLATE |



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.05
ECN 10-546

| | | | |
|------------|---|-----|----------|
| C | REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A. | MB | 10.08.05 |
| B | BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4088-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)(C82). SIDE VIEWS ADDED (C1-4)(D1-4). | JPH | 10.03.25 |
| A | NEW ISSUE | JPH | 10.03.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | ALS | | |
| DRAWN | SC | | |
| CHECKED | SC | | |
| MFG. APPR. | MP | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 10.08.05 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4018

REV. C
SHEET 1 OF 4

TITLE
SHORT BASKET LID ASSY (350)

SCALE
NTS

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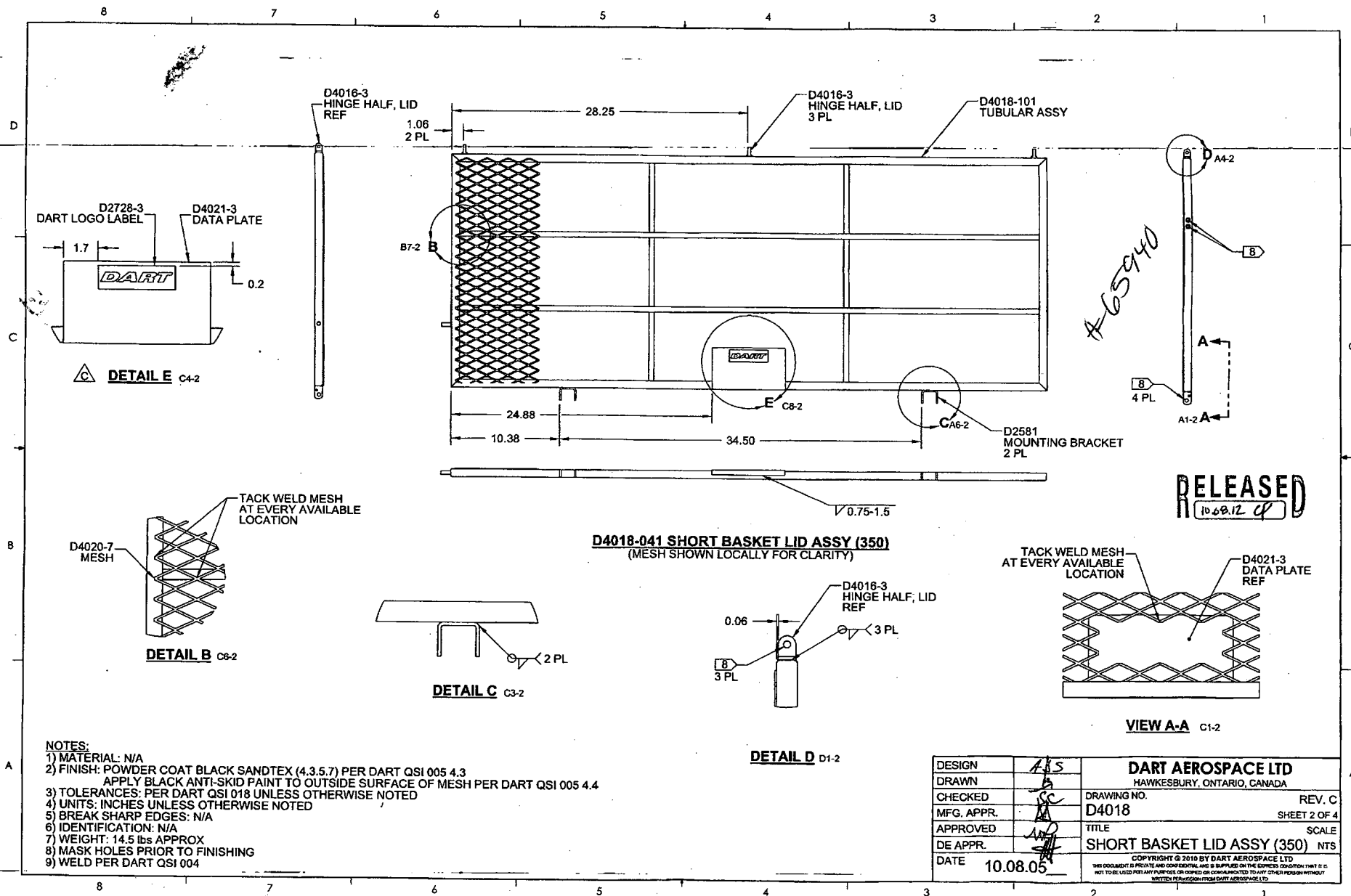
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NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.5 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

| | | | |
|---|----------|--|--------------|
| DESIGN | AS | DART AEROSPACE LTD | |
| DRAWN | SC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | SC | DRAWING NO. | REV. C |
| MFG. APPR. | SC | D4018 | SHEET 2 OF 4 |
| APPROVED | SC | TITLE | SCALE |
| DE APPR. | SC | SHORT BASKET LID ASSY (350) | NTS |
| DATE | 10.08.05 | COPYRIGHT © 2010 BY DART AEROSPACE LTD | |
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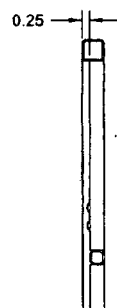
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NOTE: Date & initial all entries

| ITEM | QTY -101 | P/N | DESCRIPTION |
|------|-------------|-----------|--------------------------------|
| | X | D4018-101 | TUBULAR ASSY, BASKET LID (350) |
| 1 | 2 | D4018-1 | RIB |
| 2 | 2 | D4018-3 | RIB |
| 3 | 6 | D4018-5 | RIB |
| 4 | 1 | D4035-041 | BASKET LID RIB ASSY, FWD |
| 5 | 1 | D4035-043 | BASKET LID RIB ASSY, AFT |

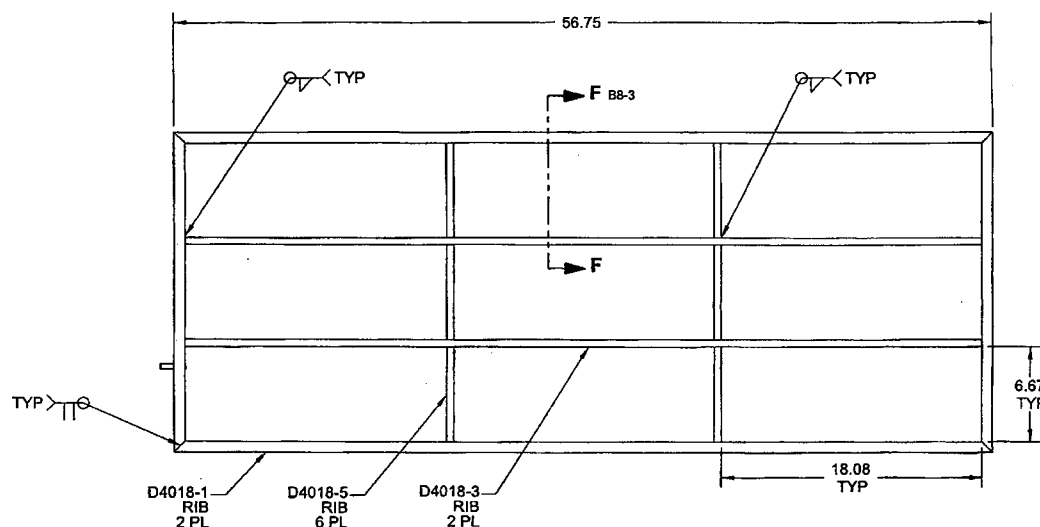


D4035-041
RIB ASSY, FWD

SECTION F-F C3-3



D4035-043
RIB ASSY, AFT



8 D4018-101 TUBULAR ASSY, BASKET LID (350)

RELEASED
10.08.05

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

| | | | |
|------------|----------|--|--------------|
| DESIGN | AS | DART AEROSPACE LTD | |
| DRAWN | AS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | SC | DRAWING NO. | REV. C |
| MFG. APPR. | SC | D4018 | SHEET 3 OF 4 |
| APPROVED | SC | TITLE | SCALE |
| DE APPR. | SC | SHORT BASKET LID ASSY (350) | NTS |
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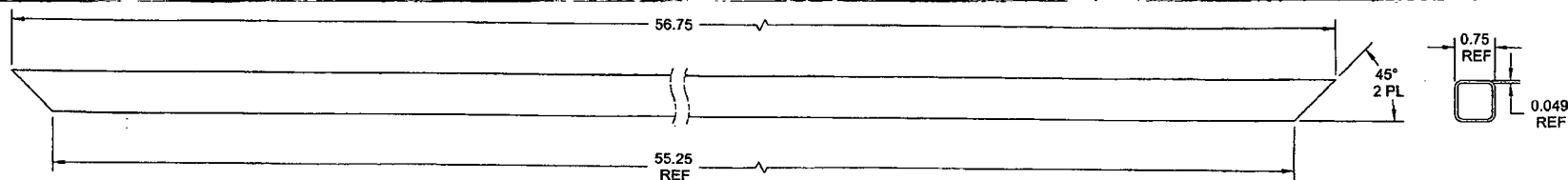
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NOTE: Date & initial all entries

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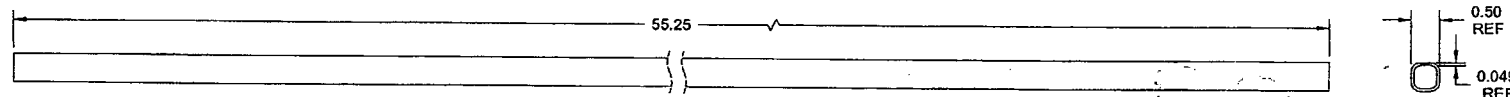
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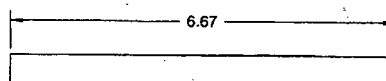


D4018-1 RIB

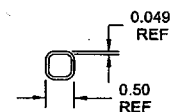
#65940



D4018-3 RIB



D4018-5 RIB



RELEASED
18.08.12

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

| | | | |
|------------|----------|--|--------|
| DESIGN | ALS | DART AEROSPACE LTD | |
| DRAWN | ISC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | ISC | DRAWING NO. D4018 | REV. C |
| MFG. APPR. | ISC | SHEET 4 OF 4 | |
| APPROVED | ISC | TITLE | SCALE |
| DE APPR. | ISC | SHORT BASKET LID ASSY (350) NTS | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries